

Fig. 2

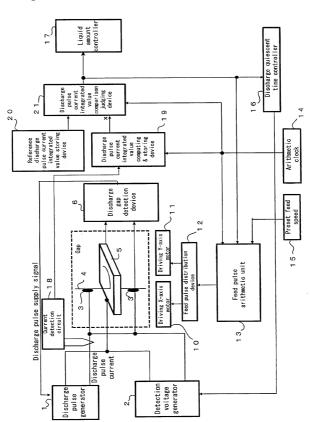


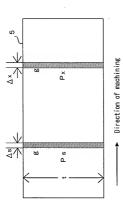
Fig. 3

 ${\bf P}_{\rm S}$. Reference discharge pulse number per unit time T ${\bf P}_{\rm A}$. Discharge pulse number per unit time T

 Δ_s : Distance movable with reference speed discharge Δ_v . Distance movable with discharge nulse number

 $\Delta \times$: Distance movable with discharge pulse number Px per unit time T w : Amount of machining per discharge pulse

t : Plate thickness
g : Machining groove width



Generation of Amount of Movement by Change in Amount of Machining

Preset feed speed which is used as a reference Distance movable per unit time T given by the preset feed speed SPD which is used as reference, $\Delta s = SPD * T$

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: Reference discharge pulse number

: Distance moveble with discharge pulse number $\mbox{\bf Px}$ per unit time $\mbox{\bf T}$: Discharge pulse number per unit time I ž

 $\Delta x = \Delta s * \Delta x / Ps$ =SPD * T * (Px / Ps)

×

× РВ

Fig. 5A

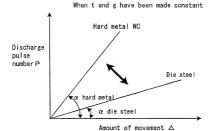


Fig. 5B

When w and g have been made constant

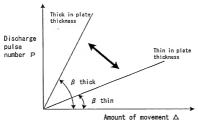


Fig. 5C

When only g has been made constant

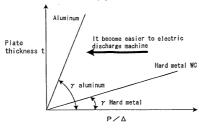


Fig. 6A

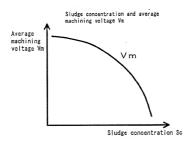


Fig. 6B

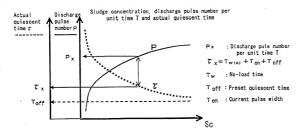


Fig. 7A

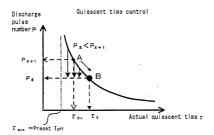


Fig. 7B

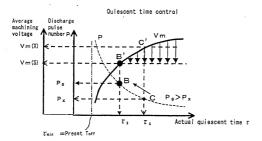
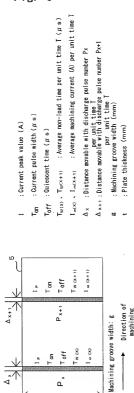
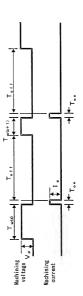


Fig. 8





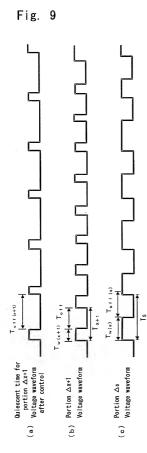


Fig. 10

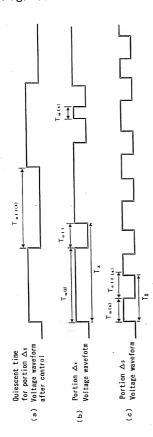


Fig. 11

 $\Delta_{\rm s}$; Distance movable with discharge pulse number Ps per unit time I

Distance movable with discharge pulse number Px per unit time T

: Machining groove width (mm)

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В

: Amount of machining per discharge pulse : Plate thickness (mm)

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; Amount of machining to be removed by reference discharge pulse number ${\sf Ps} \propto {\sf amount}$ of sludge to be discharged by preset amount of liquid fRs : Amount of machining to be removed by discharge sludge to be discharged by amount of liquid FRx pulse number Px per unit time I ∞ amount of ð

> Dirction of machining Machining groove: g width

Fig. 12

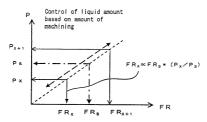
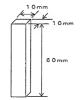
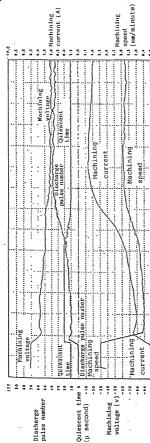


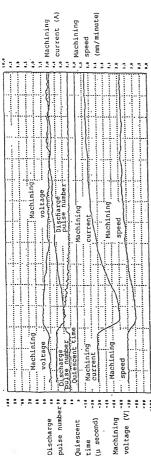
Fig. 13



Machining elapsed time (10 seconds/div)

Fig. 14





Machining elapsed time (10 seconds/div)

Fig. 16

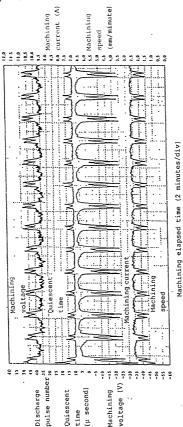
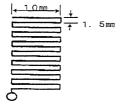


Fig. 17



Machining start

Fig. 18

